

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024717**Date Inspected:** 18-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Magnetic Particle Testing

Lift 14 East at Bay # 14

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment 14 East Anchorage Stiffener. The weld designation reviewed is as follows:

Seg3019BB-151

SA3363-001-010

SA3363-001-011

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Seg3019BC1-011

Seg3019BC1-012

Please refer Magnetic Particle Test Report TL-6028 for more comprehensive details.

Bike Path at Bay # 19

This QA Inspector performed Dimension Control Inspection on the Bike Path bottom plate for flatness check across the longitudinal butt weld. Flatness check was performed on following mentioned Bike Paths and Bike Path are identified as:

BK-025A.

The QA Inspector measured the flatness using 600mm long straight edge across the Butt (CJP) weld and using 1500mm long straight edge between the stiffeners which are plug weld to bottom plate.

Observed flatness within the allowable tolerance.

The result of the inspection was informed to ZPMC QC Mr. Guo Xing Hiu, ABF Mr. Peng Wen Jung and Caltrans Lead Inspector Mr. Mark Miller and Mr. Hiranch Patel.

Segment 14 East at Bay # 14

This QA Inspector performed Dimension Control Inspection on the weld connecting the Deck Panel to Edge Panel and observed flatness out of tolerance by 5mm to 8mm in a length starts from 1380mm to 3940mm, Y location pulled from PP 128.7 towards PP 127.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 14 East at Bay # 14

This QA Inspector performed Dimension Control Inspection on the weld connecting the Deck Panel to Deck Panel and observed flatness out of tolerance by 10 to 16mm with single point contact in a length starts from 2800, Y location pulled from PP 126 towards PP 127.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 13 West at Blast Shop # 4

This QA Inspector performed Dimension Control Inspection at the Side Panel between PP 119 towards PP 119(-1500) and PP 119 towards PP 119(+1500) for measuring the skin flatness.

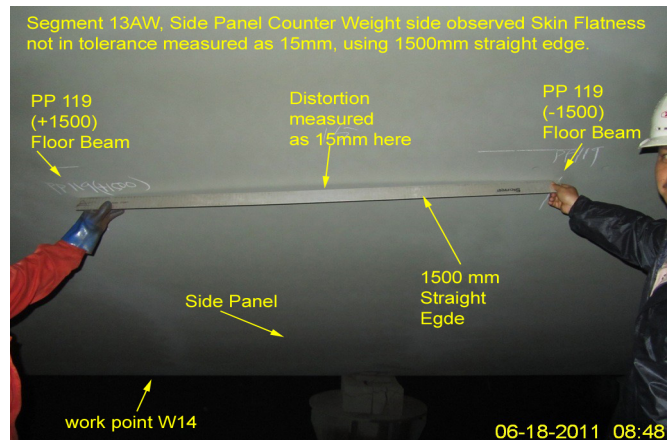
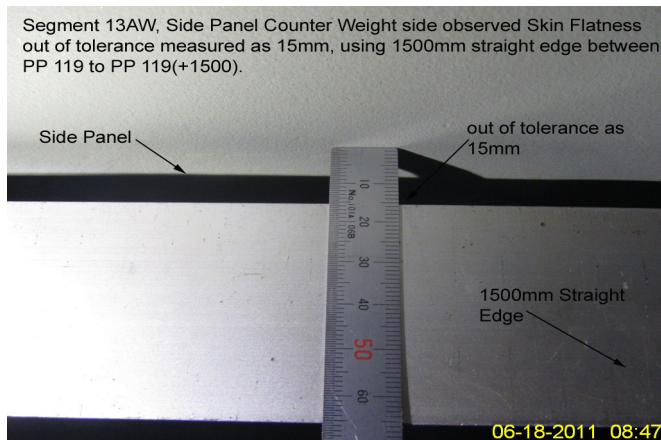
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Measured Skin Flatness was out of tolerance ranging between 6mm to 15mm, Y locations was pulled from work point W14 (Start Point 1550 mm till 4720mm) towards W16.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

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Reviewed By: Miller, Mark

QA Reviewer